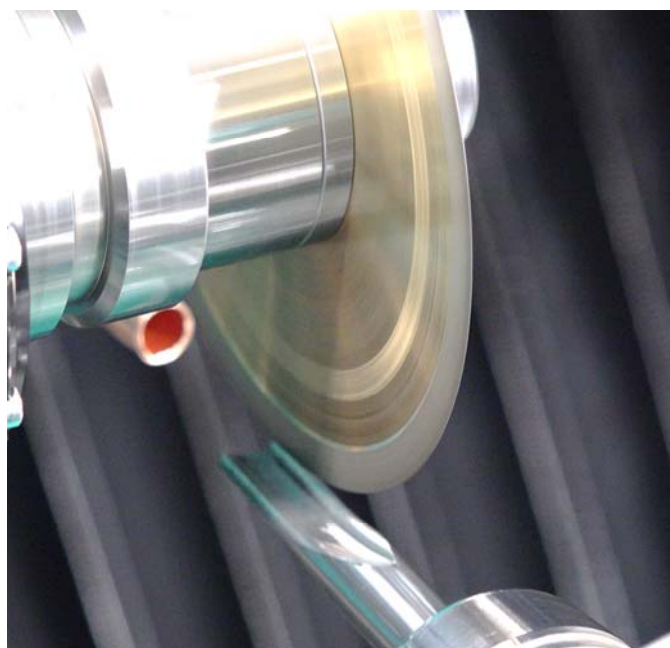


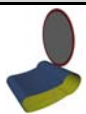
Form-Punch DXF

A27-010

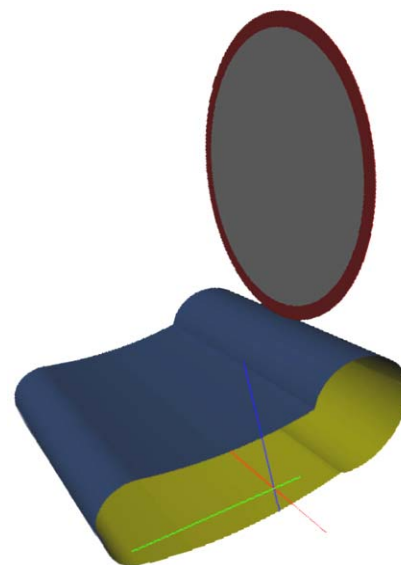
Ground with a single 1V1 wheel from solid blank diameter 12mm. Standard profiling with additional oscillation mode is used to generate the complete form. Face grinding can be done with an attitional process. Ground profile lenght is 20mm with a point resolution of 0.005mm.



1. Cycletime for Production

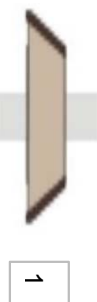
Workpiece: Ø12 L100, point res. 0.005 Material CARBIDE	
Operations	 profil oscill.
Feed [mm/Min]	10000
Power [kW]	1
Cutting speed [m/s]	22
Used wheels	1
Grinding time [s]	2316
Total cycle time	38 Min 36

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.



2. Used Grinding Wheels

1	1V1 Ø125 D46 M V25° R0.1
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3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NGS

Control: Fanuc 31iB 5

Accessories:

Responsible engineer: OP, 20.7.16

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto Qg1

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